

Date: Friday, 9/14/2007 2:01:49 PM
 User: Kim Johnston

Process Sheet

SPLIT-1

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CROSSTUBE EXTRUSION (206L)		
Job Number	: 34684					
Estimate Number	: 10025					
P.O. Number	: N/A		Part Number	: D6002115		
This Issue	9/14/2007	S.O. No.	N/A	Drawing Number	: D6002 REV A	
Prshtr Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: A		
Previous Run	: 29113		Material	: N/A		
Written By			Due Date	: 1/30/2008		
Checked & Approved By			Qty:	27	Um:	Each
Comment	: Est Rev:B 00.12.15 Added: Issue P/O EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
	Comment: PURCHASING Issue P/O <u>4611</u>	<u>CLO 7/09/18</u>
	a) Extrude as per Dwg D6002 b) Material: 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) seamless aluminum tube c)Minimum ultimate tensile strength = 77 ksi d)Minimum tensile yield strength=66 ksi e)Material certification required	(27)
2.0	D6002115P	Crosstube material
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 27.0000 Each(s) Crosstube material	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached	<u>PC 8/1/03 (30)</u>
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK Ensure Material certification comply to Dwg D6002	<u>5 08/01/04 (30)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 68/01/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/14/2007 2:01:49 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSTUBE EXTRUSION (206L)

Job Number: 34684

Part Number: D6002115

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: MAT 26

J.F.

08/01/04

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1208/01/04
(3d)

Job Completion



ini 2008/1/14

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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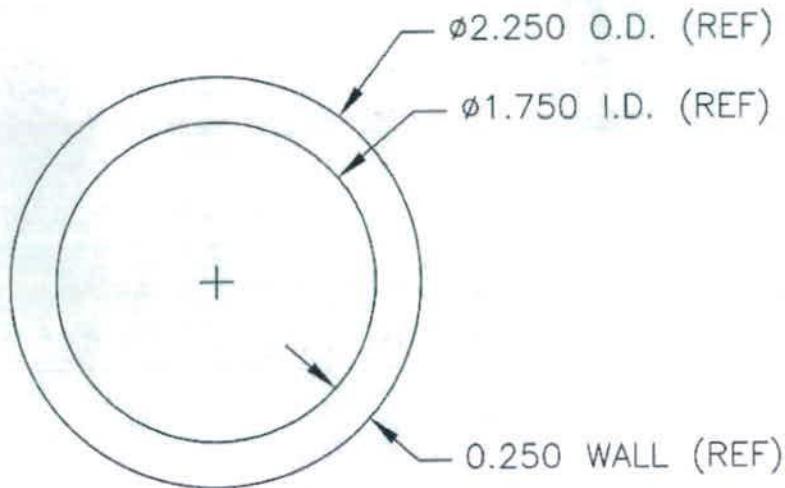
NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D6002	REV. A SHEET 1 OF 1
DATE 00.11.22		TITLE CROSSTUBE MATERIAL	SCALE 1:1
A	00.11.22	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
00.11.24 *OK*



NOTES

1) D6002-XXX CROSSTUBE

LENGTH

WHERE XXX IS LENGTH IN INCHES

EG. 115" LONG TUBE: D6002-115

2) MATERIAL: 2.250 OD x 0.250 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.

MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi

MINIMUM YIELD TENSILE STRENGTH = 66 ksi

3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:

O.D.: ± 0.006 MEAN (± 0.012 INCLUDING OVALITY)

WALL: ± 0.008 MEAN (± 0.025 INCLUDING ECCENTRICITY)

LENGTH: XXX $+0.125/-0.000$

STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH

4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

SHIPPING
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 34684



TUBES LIMITED

100 Road, Redditch, Worcestershire B98 7HN, England
Telephone (01527) 484500, Facsimile (01527) 484501

Approved Certificate According to EN10204:2004 3.1

For all Customer and 3rd Party approvals
visit www.batubes.com

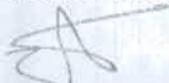
No. C/151439/1

				Your Order No PO00004611	Other Tests Passed												
				Your Part No D6002 -115P													
				Our Order No 94945/1													
				Packing Note No 151439													
				Date 20/11/07													
				Packages 1 CASE													
Description				Specification 7075 T6 WW-T-700/7B													
Nett Weight Lbs		Tensile Test					Chemical Analysis %										H cc/ 100 gm
		Test No	0.2% Proof Stress KSI	Tensile Strength KSI	% Elongation 2in		Heat or Cast No	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Zr	
562	331211 LO	67.7	78.2	14	2N267	.09	.26	1.53	.04	2.58	.19	.01	5.85	.01	.03 .16		

CASE NO.12975

ALLOY MELTED IN THE UNITED KINGDOM

3rd Inspection Representative



Layton - For and on behalf of BA Tubes

In accordance with the RoHS directive, BA Tubes certify that the above mentioned product does not contain banned or relevant substances.

Mercury Free.

in England No. 3981395
Office: The Victoria, 150-162 Harbour City
ys, Salford, M50 3SP, England.
ration No. GB 66B 2142 26



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These results pertain only to the item(s) tested as samples by the client unless otherwise indicated.

